



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3312-03-3
Job Sheet 194528



Part No: RBE350A93-3312-03-3

Job Qty: 12 pcs

Part Name: Remover / Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG
update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	SL-154 - 1	12		6/14/19	0.00	12.00	SL-154 - 1		
		pcs							
130	QC 2	12	6/14/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S205279



Part: RBE350A93-3312-03-3

Job No: 194528

Serial No/Batch: S205279

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 06/13/19

JP AUG 27 2019

					B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
190	QC 6	12	6/14/19	0.00 0.00	QC 6 - 9	
	pcs				QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
200	Packaging 3-1 - Stock - B4B	12	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA				12 pcs	6/14/19 0.00 0.00
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

AUG 28 2019

Part Op 120 - SL-154 (MORI SL-154 LATHE) 1-Machine as per DWG. FB783 FOLIO REV: AA DWG REV:

Descriptions: 6 2-Deburr

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

170 - Issue P/O to Groupe Altech; PO 44284 -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE

4 -Certificate of Conformity is required

180 - (Receive & Inspect for Damage & Mat'l Certs)

190 - (QC6- All purchased or subcontracted products)

200 - (Identify as per dwg & Stock Location:)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.500	AISI 4140 Quenched & Tempered Steel Round Bar 1.500" Dia.	1.0800 ft (.09 ea)	120-SL-154 - 1	<u>5 188342</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-SL-154 - 1	MT-4140QT-R1.500	1	6	0

Part Specifications

Specifications could not be found.

Plex 5/3/19 12:46 PM Dart.lajeunesse.marie

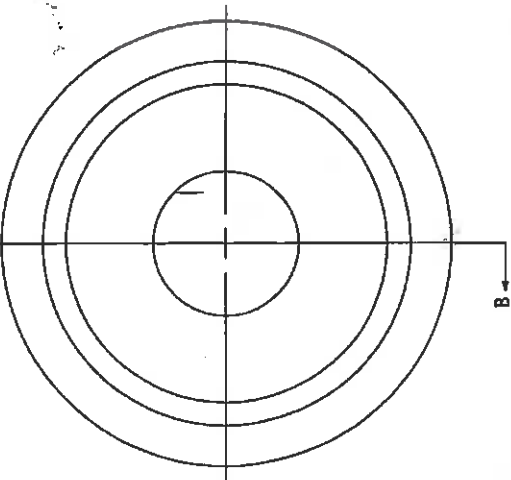
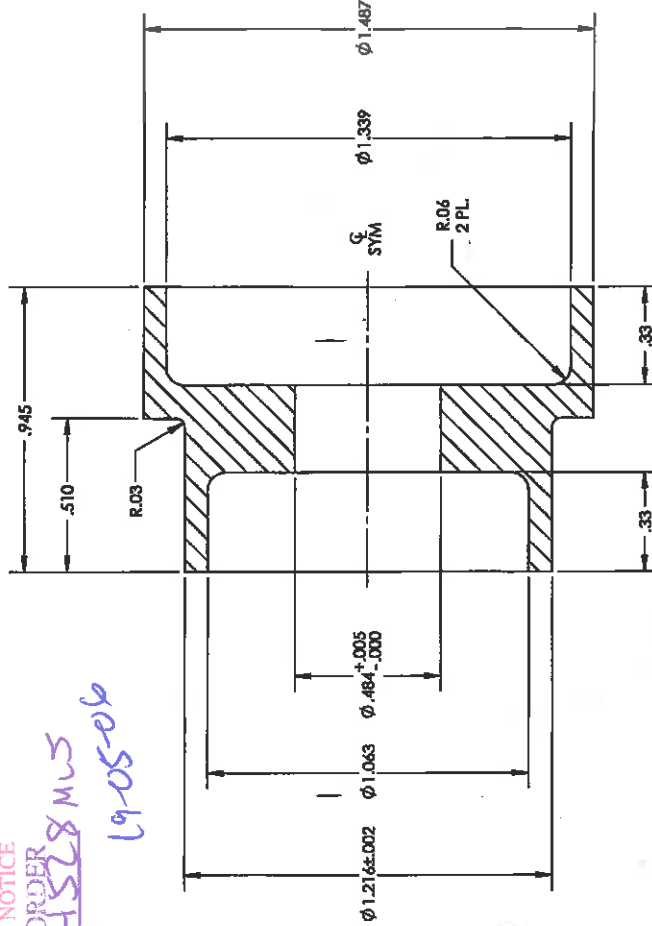
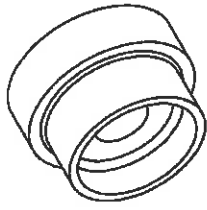
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	DIMENSION 473 CHANGED TO .484, TEMPLATE UPDATED. SPEC FOR BLACK OXIDE CHANGED, 17-4PH SS MTL OPTION ADDED	17-503	17.12.27	VM	ML
G	28-32 R _a REMOVED	18-582	18.3.1	VM	ML

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 194528 MUS

1905-06



RBE350A93-3312-03-3 REMOVER / INSTALLER

SECTION B-B

TITLE: REMOVER / INSTALLER	
PART NO.	RBE350A93-3312-03-3
REV.	G
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE ORDER ONLY. IT IS NOT TO BE REPRODUCED OR USED FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DART AEROSPACE LTD. 10000 14th Avenue, Unit 100 Richmond, British Columbia V6V 1K9 CANADA	
DESIGNED BY:	VM 12/27/2017
DRAWN BY:	VM 03/07/2018
CHECKED BY:	VM 03/07/2018
APPROVED BY:	JFC 03/07/2018
SCALE:	1:1
SHEET 3 OF 5	

- NOTES:
- 1) MATERIAL: 4140/4142 OR 17-4PH-H900 SS
 - 2) HEAT TREAT: N/A
 - 3) FINISH: 4140/4142 = BLACK OXIDE / 17-4PH = NONE
 - 4) SPEC: 4140/4142 = MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4 / 17-4PH = N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: N/A

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____		MRB (QS1042) _____																																																					
Description Work Order Deviation Disposition						Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																																																									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%; border: 1px solid black;">Pressure/Forced</td> <td style="width:15%; border: 1px solid black;">☐</td> <td style="width:15%; border: 1px solid black;">Contamination</td> <td style="width:15%; border: 1px solid black;">☐</td> <td style="width:15%; border: 1px solid black;">Power Loss/Surge</td> <td style="width:15%; border: 1px solid black;">☐</td> <td style="width:15%; border: 1px solid black;">Positioned Wrong</td> <td style="width:15%; border: 1px solid black;">☐</td> </tr> <tr> <td style="border: 1px solid black;">Bending</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Misaligned/off center</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Folio/Program</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Outside Tolerance</td> <td style="border: 1px solid black;">☐</td> </tr> <tr> <td style="border: 1px solid black;">Crushing</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">BOM/Route</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Grain Direction</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Drawing</td> <td style="border: 1px solid black;">☐</td> </tr> <tr> <td style="border: 1px solid black;">Cracks</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Broken/Damage/Defect</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Weld</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Finish</td> <td style="border: 1px solid black;">☐</td> </tr> <tr> <td style="border: 1px solid black;">Crimp/Kink/Ripple/Wave/Twist</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Incomplete/Unclear Instructions</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Wrong Stock Pulled</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Part Lost/Missing</td> <td style="border: 1px solid black;">☐</td> </tr> <tr> <td style="border: 1px solid black;">Marks/Chatter</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Drill Holes</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Out of Sequence</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Misread</td> <td style="border: 1px solid black;">☐</td> </tr> <tr> <td style="border: 1px solid black;">Mislabeled</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Fit/Function</td> <td style="border: 1px solid black;">☐</td> <td style="border: 1px solid black;">Off-set/Set-up</td> <td style="border: 1px solid black;">☐</td> <td></td> <td></td> </tr> </table>						Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐		
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		Other/Details: _____																																																													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044284



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044284

PO Date: 8/19/19

Due Date: 8/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194529	RBE350A93-3312-03-5	Seat -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed -	-	8/27/19	18 pcs	0 pcs	18 pcs	\$1.35/pcs	\$24.30
2	199074	RBST2120-11	Primary Seat -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -	-	8/27/19	5 pcs	0 pcs	5 pcs	\$1.48/pcs	\$7.40
3	194528	RBE350A93-3312-03-3	Remover / Installer -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed -	-	8/27/19	12 pcs	0 pcs	12 pcs	\$1.35/pcs	\$16.20

AUG 27 2019

S205409

AUG 27 2019

S205279

DAS
61
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044284



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	194530	RBE350A93-3312-03-7	Washer -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-16173 GRADE 4 -Certificate of Conformity is required	Firmed	-	8/27/19	18 pcs	0 pcs	18 pcs	\$1.35/pcs	\$24.30
5	194562	RBE350A94-3700-C-03	Bolt -Issue P/O; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	20 pcs	0 pcs	20 pcs	\$1.55/pcs	\$31.00
6	196318	RBE350A93-3303-02-5	Extractor Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/27/19	25 pcs	0 pcs	25 pcs	\$1.05/pcs	\$26.25
Grand Total:											\$129.45

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/20/19 4:25 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021664 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
26-Aug-2019		Jigar Patel				POHB044284			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBST2120-11 Rev.	RBST2120-11 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13924C, CLASS -		OXIDE-BLACK CH	5	5	0	0	0
3	RBE350A93-3312-03-3 Rev.	RBE350A93-3312-03-3 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13964, CLASS - 1 OR MIL-C-16173 GRADE - 4		OXIDE-BLACK CH	12	12	0	0	0
4	RBE350A93-3312-03-7 Rev.	RBE350A93-3312-03-7 OXIDE BLACK [OXIDE BLACK] AS PER MIL-C-13964, CLASS - 1 OR MIL-C-16173 GRADE - 4		BLACK-OXIDE CH	18	18	0	0	0
6	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 OXIDE BLACK [OXIDE BLACK] MIL-C-23942C, CLASS 1		BLACK-OXIDE CH	25	25	0	0	0

RECEIVED

AUG 26 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jp. Jigar

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.